

Work Order ID 62665 - 2 *split*



Page 1

Thursday, October 07, 2010 8:06:50 AM

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 10/6/2010 Start Qty: 100.00 *SD*

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 100.00

Customer:

Reference:

Approvals:

Process Plan:

Date: *10/10/07*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev F *G*

100

0.00



Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch: _____

110



HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

DWG REV: _____

POLIO REV: _____

(Check for crack while loading into the machine.)

2- deburr rough edges

CL 10/10/07 (100)

*Issue P.O. 122091
Machine per drawing D2230 Rev F. G*

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Page 2

Item ID: D2230-1

Accept

Revision ID:

Item Name: Lug

Start Date: 10/6/2010 Start Qty: 100.00

Required Date: 10/15/2010 Req'd Qty: 100.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



Quality Control

QC2 Inspect parts off machine FAI/FAIB

0.00

Receive + inspect for transit damage

Memo

0.00

Ensure (S) C attached

10/11/01 (50)

130



QC

Quality Control

QC8 Inspect parts - second check

0.00

QC6

Memo

0.00

8/10/11/01

count to
X50

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

=> JH 10/11/01

X57

Work Order ID 62665

Thursday, October 07, 2010 8:06:50 AM

Page 3

Item ID: D2230-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug

Start Date: 10/6/2010 Start Qty: 100.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 100.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

50 BR 10-10-1

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

M115291

Memo

0.00

Powder Coating

START TIME: 9:25
OVEN TEMPERATURE: 320°
FINISH TIME: 9:55

50 BR 10-11-2

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

=> M 10/11/07

50

Work Order ID 62665

Thursday, October 07, 2010 8:06:50 AM

Page 4

Item ID: D2230-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug

Start Date: 10/6/2010 Start Qty: 100.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 100.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location: ST476

0.00



Packaging

Memo

0.00

Packaging

EP 10/11/02 (50)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/04

MF

10-11-4

Picklist Print

Page 1

Thursday, October 07, 2010 8:06:54 AM

Work Order ID: 62665



Parent Item: D2230-1



Parent Item Name: Lug

Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D 100.11.01 Added inspection level 8, and removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			110	f	342.8550	0.0683	7.189474			



Lug Extrusion



Location

Loc Qty

Loc Code

MAT06

342.8549795

43722

180

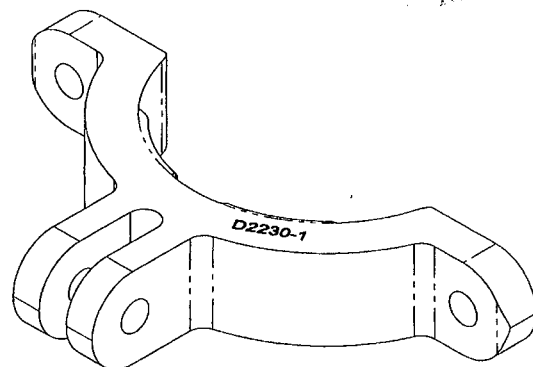
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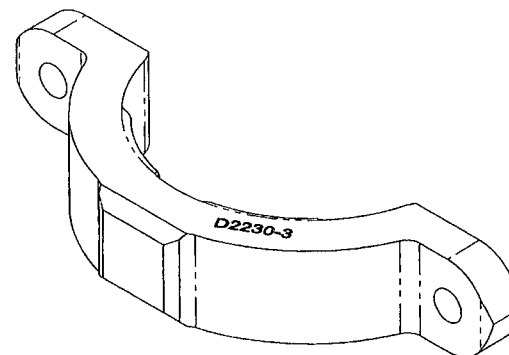
3.595 02/10/10/07

D2230-1P

02/10/11/01 x50



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
09/06/25/07

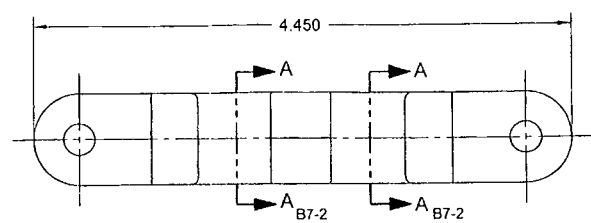
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	[Signature]	DRAWING NO.	REV. G
MFG. APPR.	[Signature]	D2230	SHEET 1 OF 3
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS FOR INTERNAL USE ONLY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



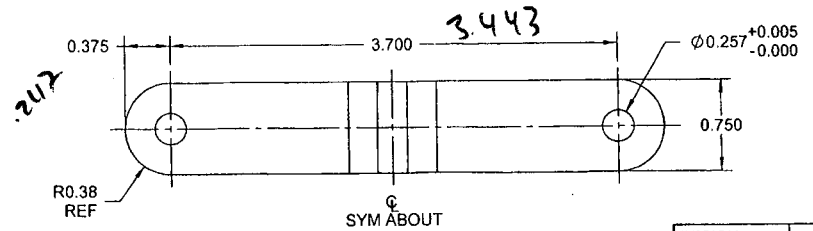
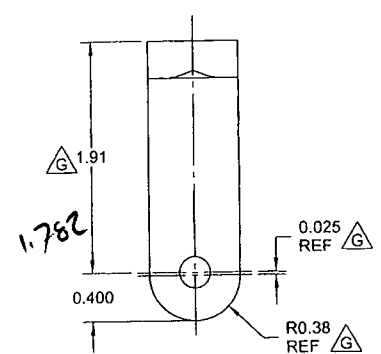
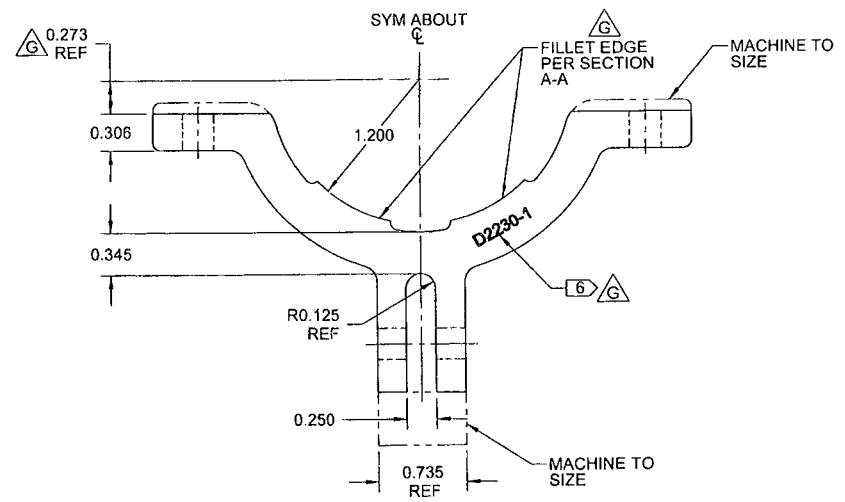
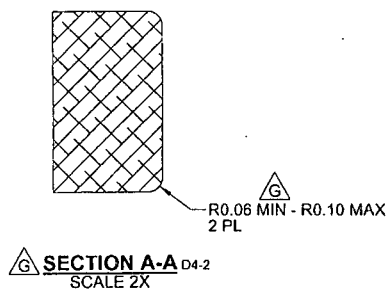
NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

8 7 6 5 4 3 2 1



who 621465



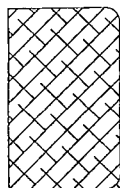
D2230-1 MOUNTING LUG

RELEASED
09/06/75

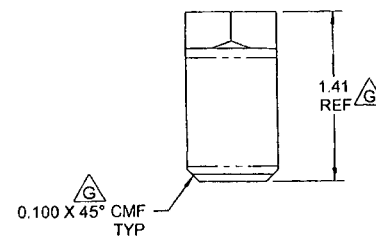
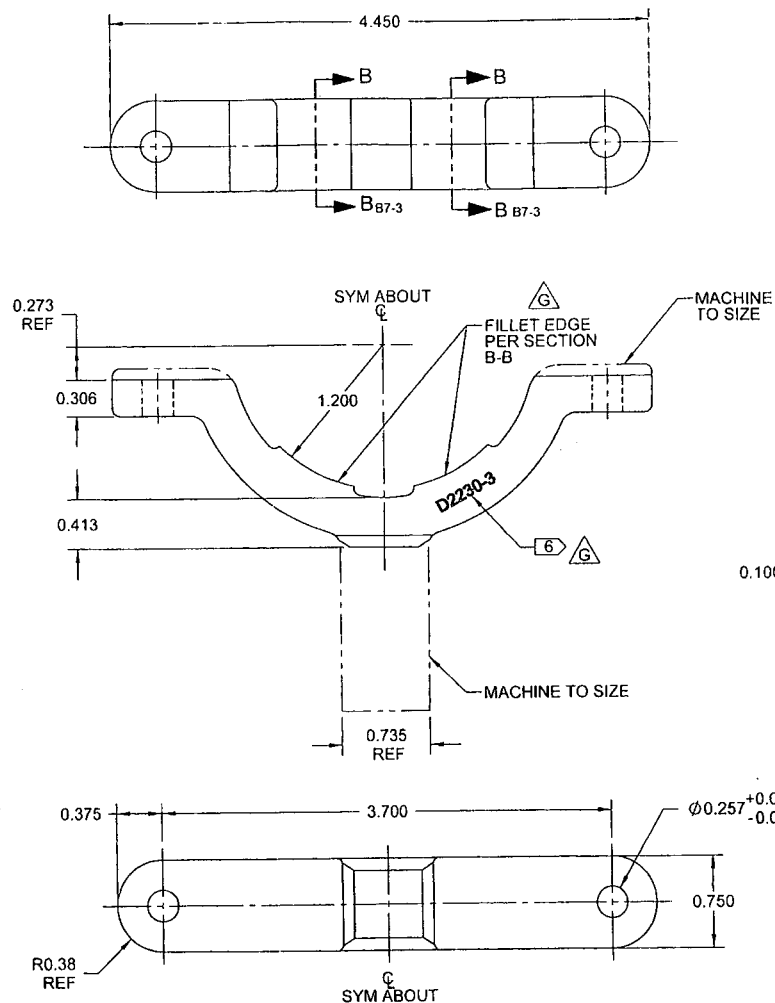
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DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		MOUNTING LUG	SCALE NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/2017

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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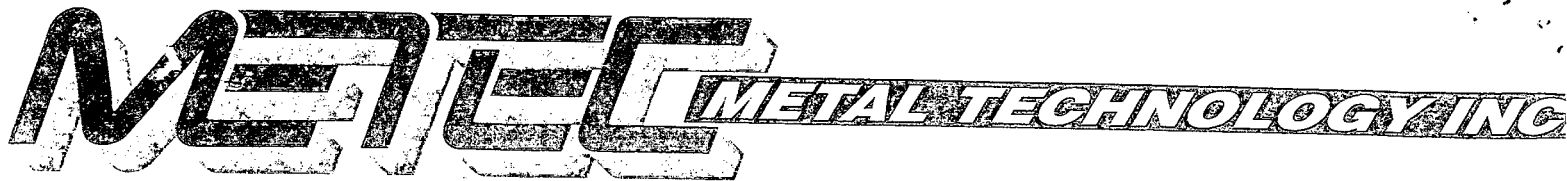


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **17541**
Date: Oct 29, 2010
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 12709	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3394-3 Lug as per drawing D3394 Rev.B Material supplied by DART D2423 B45800	Each	40		
D3394-3 Lug as per drawing D3394 Rev.B Material supplied by DART D2423 B45800	Each	24		
D2731-7 Lug as per drawing D2731 Rev.C Material supplied by DART D2423 B45800	Each	24		
D2731-7 Lug as per drawing D2731 Rev.C Material supplied by DART D2423 B45800	Each	20		
D2230-3 Mounting Lug as per drawing D2230 Rev.G Material supplied by DART D2423 B45800	Each	100		
D2230-3 Mounting Lug as per drawing D2230 Rev.G Material supplied by DART D2423 B45800	Each	80		
D3235-1 Mounting Lug as per drawing D3235 Rev.A Material supplied by DART D2423 B45800	Each	50	50	
D2230-1 Mounting Lug as per drawing D2230 Rev.G Material supplied by DART D2423 B45800 8/10/11/01	Each	100	50	
D4091-1 Lug as per drawing D4091 Rev.A Material supplied by DART D2423 B45800	Each	10	10	
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:


same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D3235-1	Mounting Lug	12709
50	D2230-1	Mounting Lug	12709
10	D4091-1	Mounting Lug	12709

MATERIAL: Supplied by DART D2324 45800

8/10/4/01
We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, October 29, 2010